

**Work Order ID 59568**

Tuesday, June 08, 2010 9:18:24 AM



Page 1

Item ID: D3574-1

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 6/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:   *M*  Date:   10-6-01  

Tooling:

Date:           

Run Start

QC:           Date:           SPC (Y/N):           Date:           

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev:   *B*   ☐ Prog Rev:   *B*   ☐ 2-  
Deburr if necessary  *HB 10-6-14*    *(4)*  

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

  *HB 10-6-14*  

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

  *8 10/6/14*    *(x4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

6/10/06/15 (V)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sublocking

(4)

150



Identify as per dwg &amp; Stock Location: P00

0.00

Packaging

Memo

0.00

Packaging

S9572

6/10/06/16 4

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Page 3

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/17  
ME  
10-6-16

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 08, 2010 9:18:31 AM

Page 1

Work Order ID: 59568

Parent Item: D3574-1

Parent Item Name: Cabin Floor Protector

Comments: IPP Rev :A New Issue 07-01-22 EC

Start Date: 6/8/2010

Required Date: 6/17/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,369.206	33.6	134.4672			



GE PLASTICS LEXAN SHEET



1310-6-4

## Location

## Loc Qty

## Loc Code

MAT

1369.2068

111710

64

112585

155.783

114032

1149.4238

114032

④

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 59568
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-1
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.006	X			
7.37	+/-0.030	7.37	X			
10.75	+/-0.030	10.75	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
49.11	+/-0.030	49.11	X			
51.11	+/-0.030	51.11	X			
53.51	+/-0.030	53.51	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	X			
10.75	+/-0.030	10.75	X			
11.06	+/-0.030	11.06	X			
14.75	+/-0.030	14.75	X			
25.50	+/-0.030	25.50	X			
25.75	+/-0.030	25.75	X			
26.00	+/-0.030	26.00	X			
32.87	+/-0.030	32.87	X			
38.81	+/-0.030	38.81	X			
44.75	+/-0.030	44.75	X			
45.00	+/-0.030	45.00	X			
48.25	+/-0.030	48.25	X			
58.38	+/-0.030	58.38	X			
61.25	+/-0.030	61.25	X			
64.13	+/-0.030	64.13	X			
64.63	+/-0.030	64.63	X			
66.50	+/-0.030	66.50	X			
7.50	+/-0.030	7.50	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
10.88	+/-0.030	10.88	X			
14.50	+/-0.030	14.50	X			

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	59368
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b>	D3574-1
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> B	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	X			
18.75	+/-0.030	18.75	X			
24.13	+/-0.030	24.13	X			
26.50	+/-0.030	26.50	X			
30.50	+/-0.030	30.50	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
43.83	+/-0.030	43.83	X			
46.60	+/-0.030	46.60	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
11.50	+/-0.030	11.50	X			
16.75	+/-0.030	16.75	X			
19.00	+/-0.030	19.00	X			
22.50	+/-0.030	22.50	X			
30.75	+/-0.030	30.75	X			
32.63	+/-0.030	32.63	X			
32.75	+/-0.030	32.75	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
0.125	+/-0.010	.134	X			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-6-14	<b>Date:</b> 10/06/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

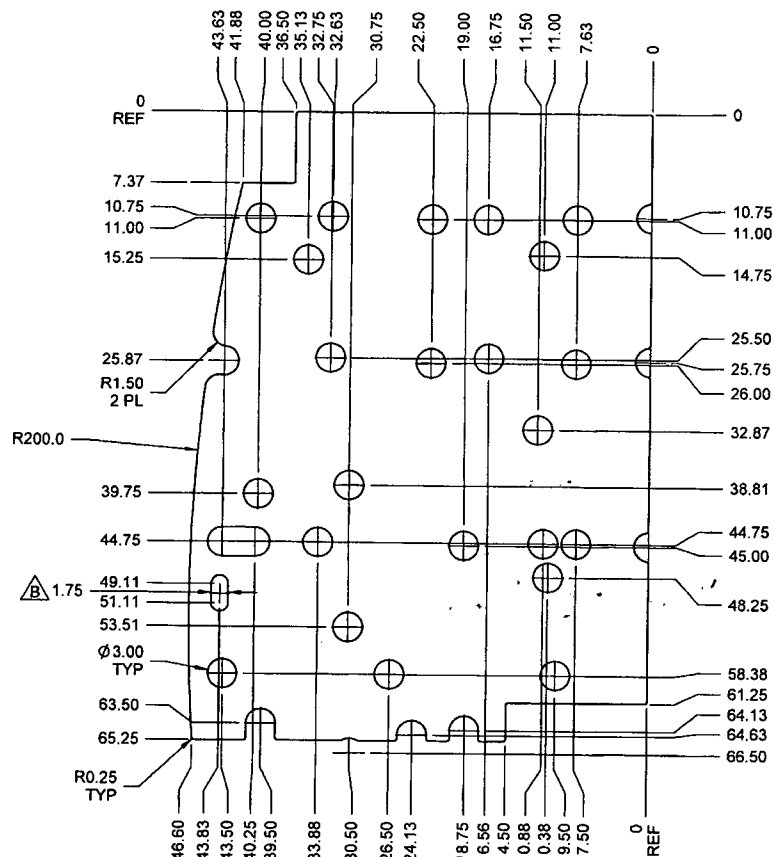
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



### D3574-1 CABIN FLOOR PROTECTOR

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59566  
BS10-6-08

RELEASED  
01/04/07

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3574 TITLE CABIN FLOOR PROTECTOR SCALE NTS REV. B SHEET 1 OF 6 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

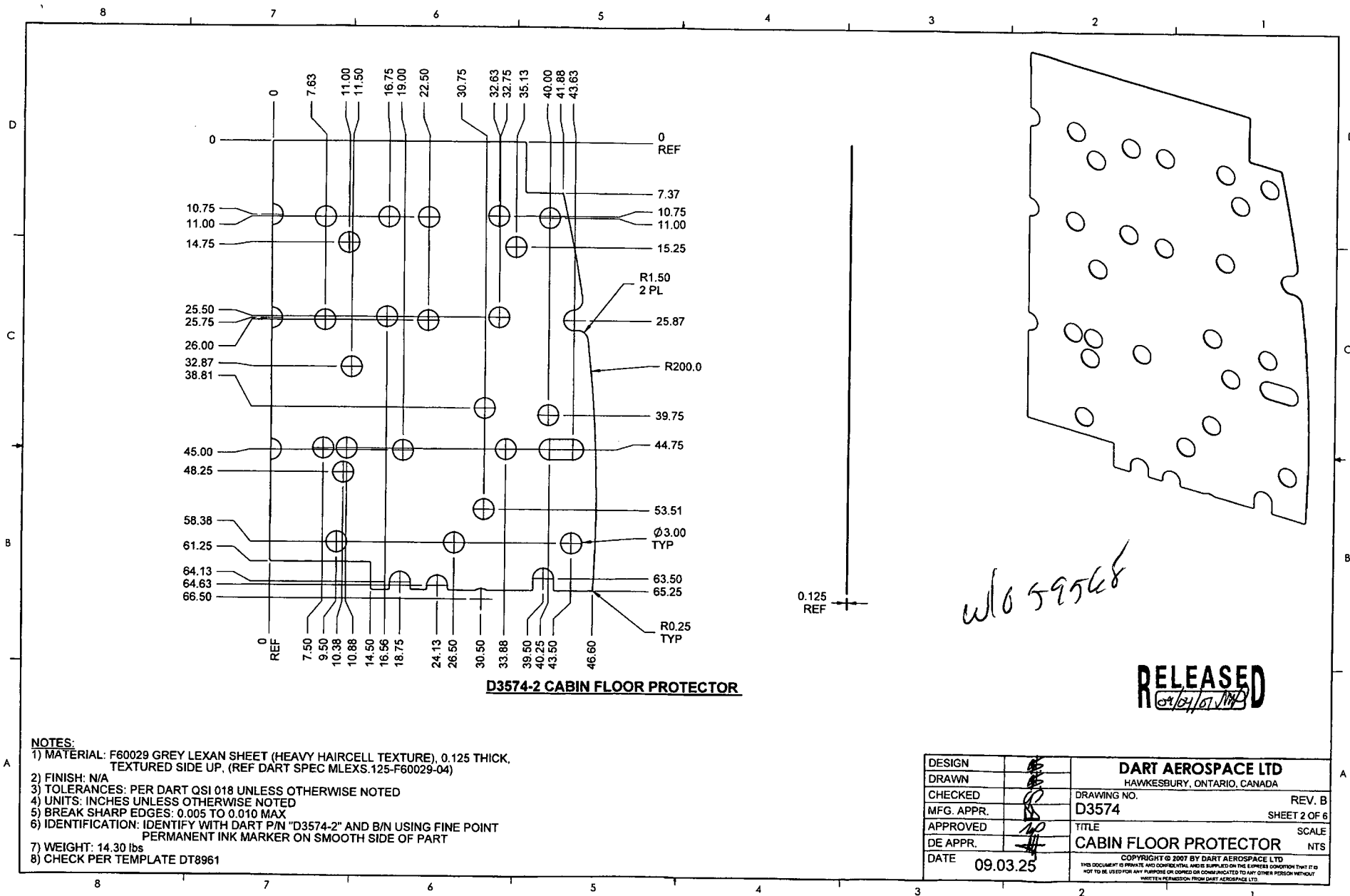
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**NOTE:** Date & initial all entries



WLO 59568

**RELEASED**  
 09/04/07

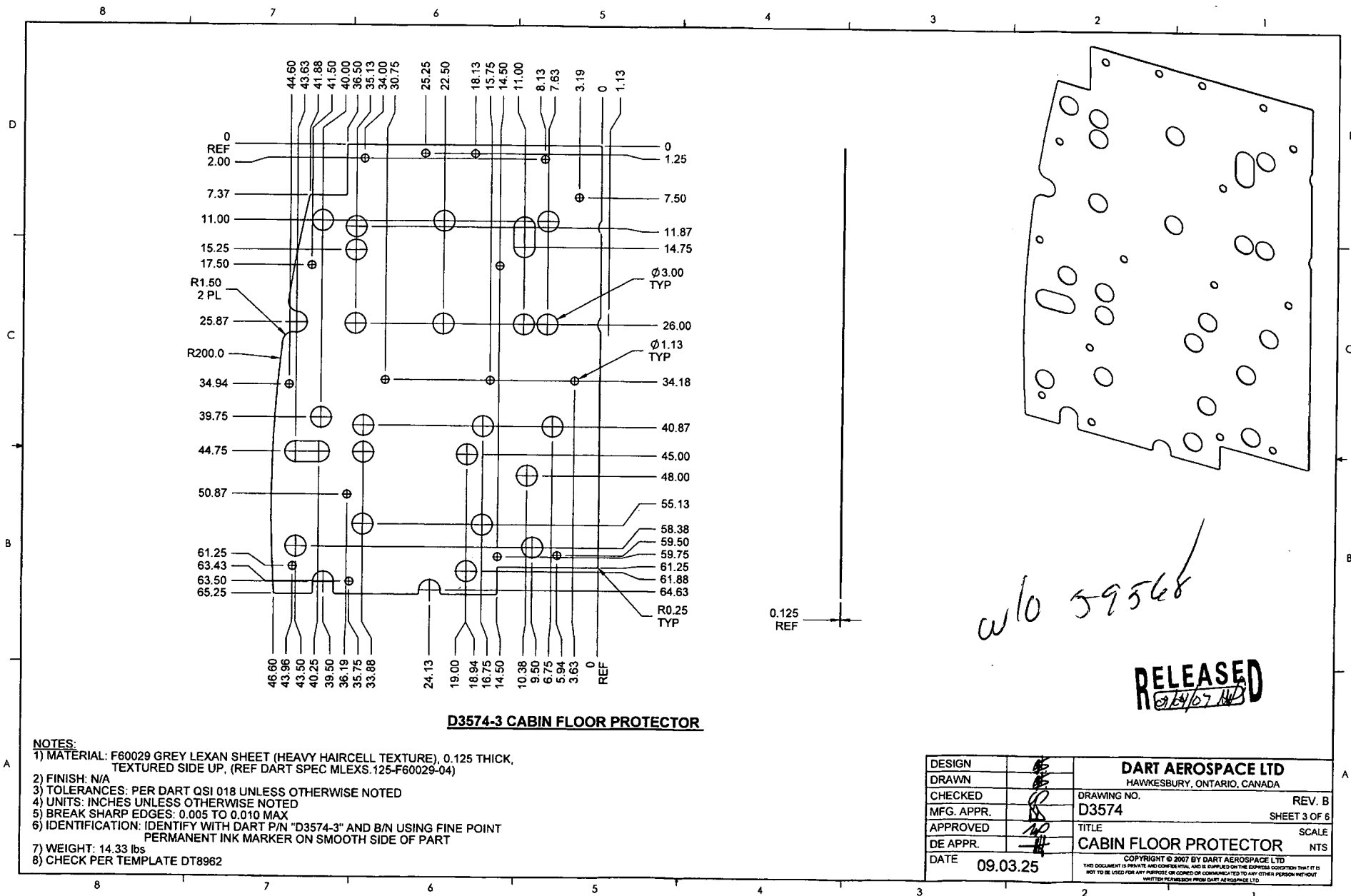
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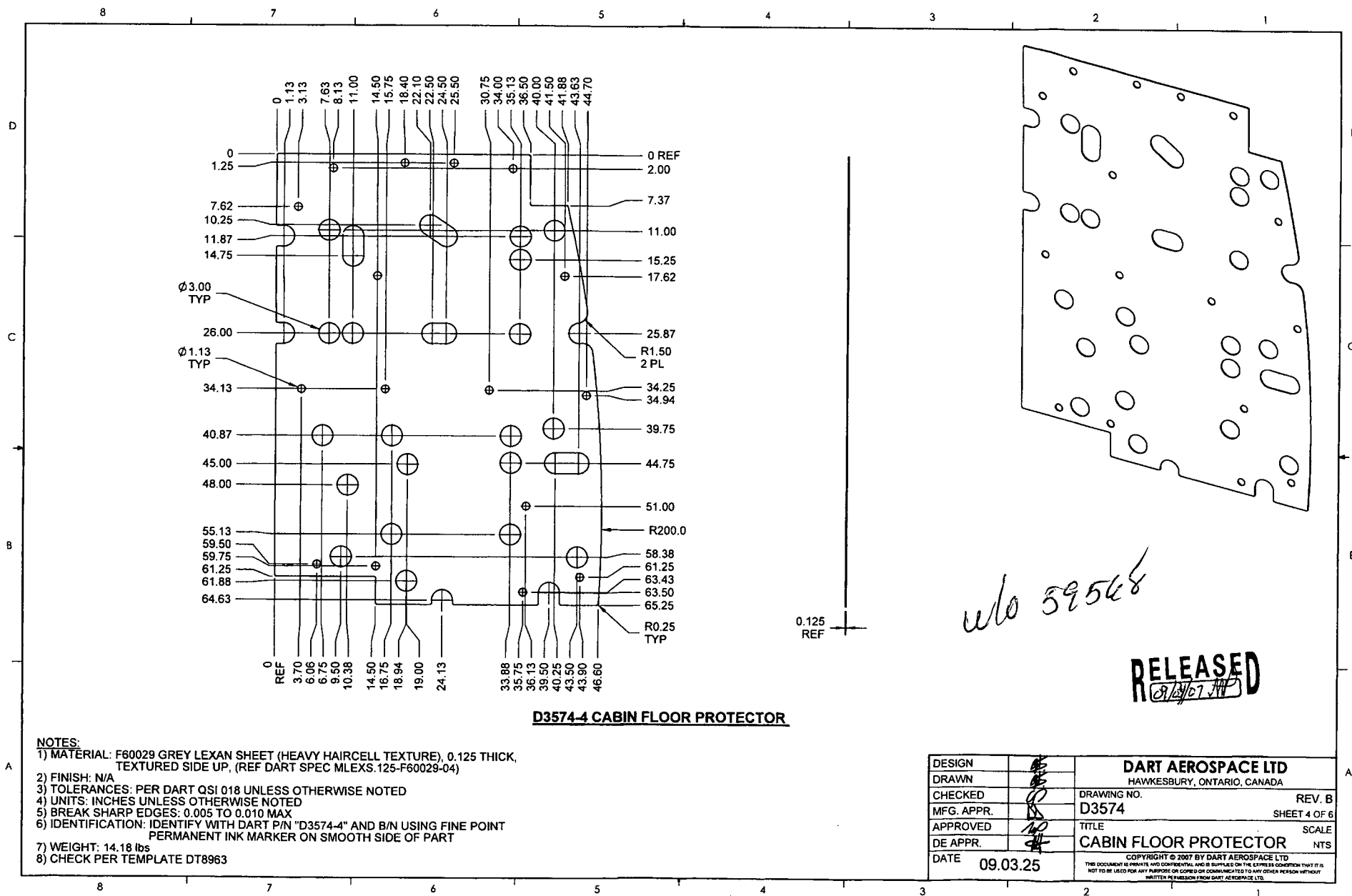
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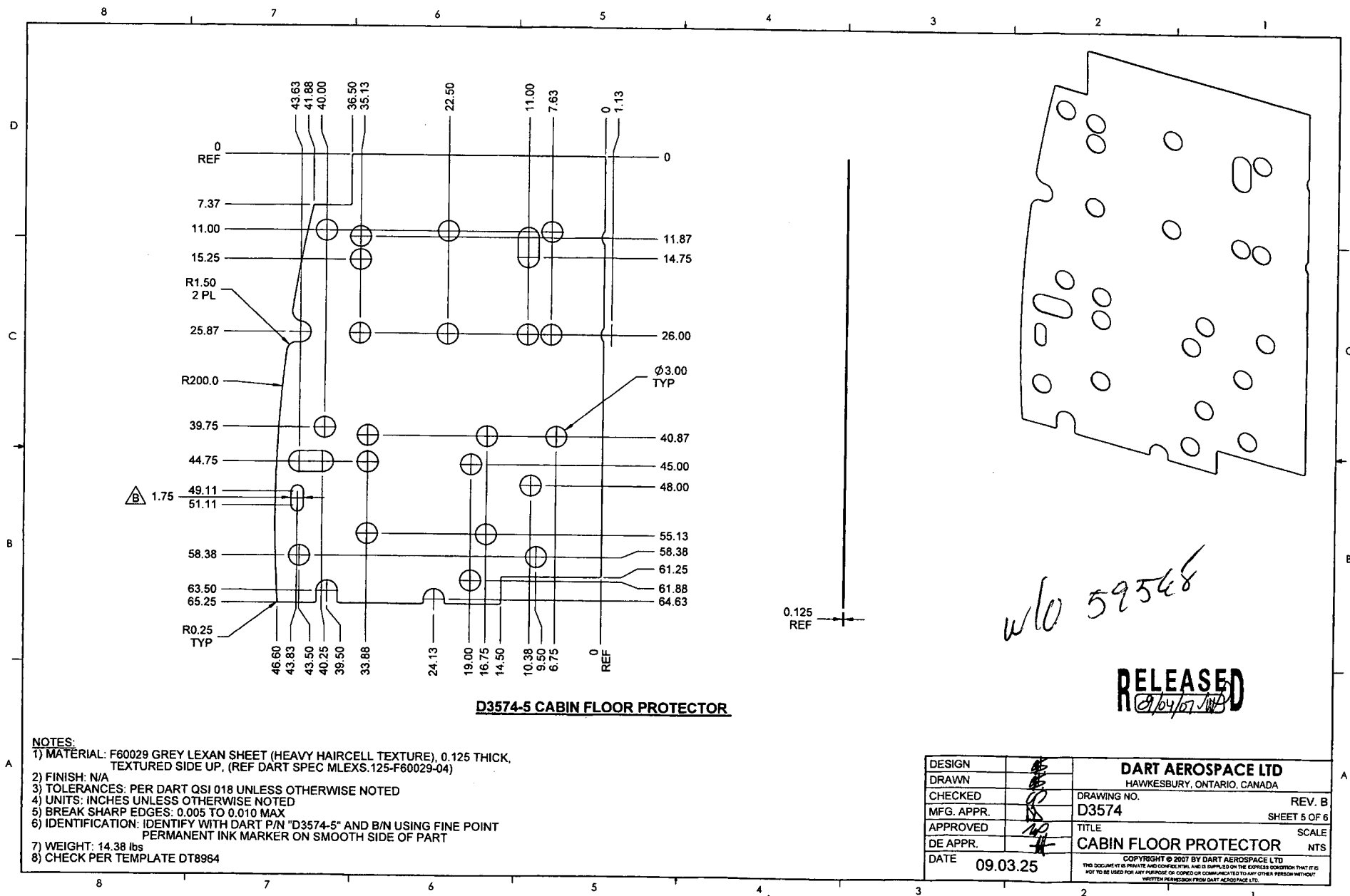
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DESIGN	<del>JS</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>JS</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JS</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>JS</del>	D3574	SHEET 5 OF 6
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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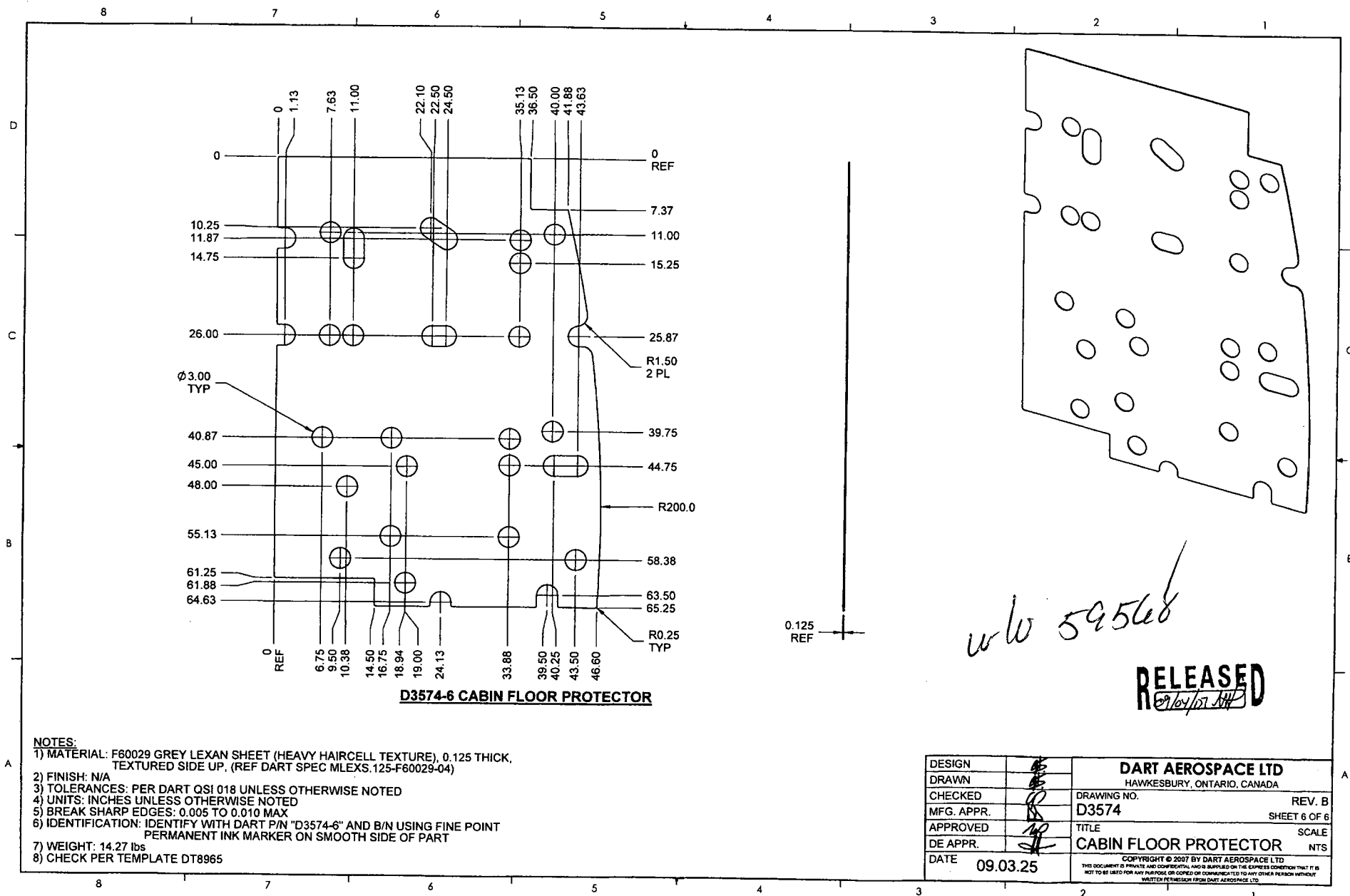
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*Ww 59566*

**RELEASED**  
*09/03/07*

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